

CLAIMS

1. A method of assembling a car body by spot welding a bridging part to a pair of side members fixed to an underbody of a car,
5 the method comprising the steps of:

installing a pair of frames at sides of a transfer line for transferring the underbody and the side members;

attaching a plurality of movable joisted-locating jigs to the frame for locating the side members and the bridging
10 part; and

spot welding the side members to the bridging part, with the side members and the bridging part clamped by the joisted-locating jigs;

wherein a transfer system is employed to convey the
15 joisted-locating jig from the frame to a first stock area and to convey another joisted-locating jig from a second stock area to the frame for performing a joisted-locating jig change.

2. The method of assembling a car body according to claim 1,
20 wherein the frame and the joisted-locating jig are located and fixed by a clamp mechanism.

3. The method of assembling a car body according to claim 1,
wherein the transfer system includes a motor, a movable rail
25 moved up and down by the motor, a fixed rail to be combined with the movable rail, and a pulley movable along the movable rail and the fixed rail, the joisted-locating jig being hung from the pulley.

4. The method of assembling a car body according to claim 3, wherein a sway prevention mechanism is furnished for preventing the movable rail from swaying when the movable rail and the fixed rail are disconnected.

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5. The method of assembling a car body according to claim 4, wherein the sway prevention mechanism includes a pair of vertical rods attached to the movable rail and a pair of fixed guides fixed to an immovable structure, the vertical rods being movable relative to the fixed guide via a roller.

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6. The method of assembling a car body according to claim 3, wherein a fall prevention mechanism is provided at the movable rail for preventing the pulley from falling out of the movable rail.

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7. The method of assembling a car body according to claim 6, wherein the fall prevention mechanism includes a stopper that turns on the predetermined pivot, the stopper being movable between a position at which the stopper engages with the pulley and a position at which the stopper is disengaged from the pulley.

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